

Date: Wednesday, 25/06/2008 12:00:05 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 40087C		
Estimate Number	: 10356		
P.O. Number	:	Part Number	: D2279
This Issue	: 25/06/2008 S.O. No. :	Drawing Number	: D2279 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 37925C	Material	:
Written By	:	Due Date	: 07/07/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JUL 08.6.25</u>		
Comment	: Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
Comment: Qty.: 0.1544 sf(s)/Unit Total : 1.8522 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2279 Batch: <u>10757</u> <u>8-7-3</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D 2279 <u>8-7-3</u> Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-Deburr if necessary <u>8-7-3</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>8-7-3</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>08/07/08</u> <u>x18</u>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Form As per Dwg D2279 <u>08/10/14</u> <u>18</u> <u>08/10/29</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/29 (18)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL 08-10-30 (18)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/10/30 (18)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

546 v/r 12/11/30 18

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/31 (18)

Job Completion



u 08/10/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

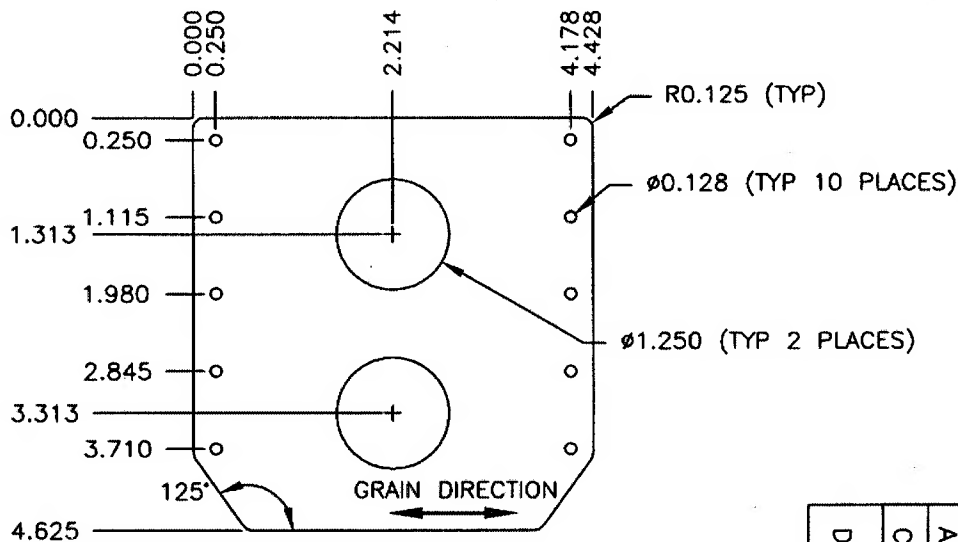
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		JP		HAMKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	JP	DRAWING NO.	REV. D
DATE		TITLE		SHEET 1 OF 1	
98.10.05		STEP SPACER		SCALE	
A		94.10.13		NEW ISSUE	
C		94.11.15		0.588 WAS 1.607 AND 3.861 WAS 4.881	
D		98.10.05		4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	



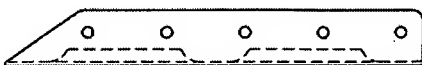
FLAT LAYOUT

FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)

R0.125

0.62

3.400



UNDER REVIEW

RELEASED
98.10.08 DS

DESIGN OK, BUT CHECK WITH
TS BEFORE MANUFACTURE

OK 4/9/09

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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WORK ORDER
400832